

Work Order ID 57252

March 31, 2010 10:15:36 AM



Page 1

Item ID: D3072-1

Revision ID:

Item Name: Bracket

Start Date: 31/03/2010 Start Qty: 10.00

Required Date: 09/04/2010 Req'd Qty: 10.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan: H

Date: 10-3-31 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3072

Rev A1

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

5052 . 090

1-Cut as per Dwg D3072 (D3072-101 flat pattern) ☐ Dwg
Rev: A1 ☐ Prog Rev: A1 ☐ 2-Deburr if necessary

10-3-31

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10-3-31

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8 10/04/01

14

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

1- deburr if necessary 2- Bend as per dwg D3072

0.00

0.00

8/8 10/6/05

14

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/04/05

14

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

11 10/04/06

14

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M105642

0.00

Memo

0.00

START TIME:

11:45pm

FINISH TIME:

320°C

=> 10/10/07

X14

Ø

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

OK 10-4-7

(14) Ø

180



Packaging

Packaging

Identify as per dwg & Stock Location: 035

0.00

Memo

0.00

PR 14/4/9 (14)

W/O:		WORK ORDER CHANGES					
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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10/04/12

MF

10-4-9

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

March 31, 2010 10:15:40 AM

Page 1

Work Order ID: 57252

Parent Item: D3072-1

Parent Item Name: Bracket


Comments: IPP B 02.01.18 Flat pattern created on dash 101. NG
IPP Rev:C 08-02-26 now water jet DD verified by:LL

Start Date: 31/03/2010

Required Date: 09/04/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.090						100	sf	49.3000	1.2284	1.8		
												
5052-H32 .090 Sheet												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT22	49.3	
100782	17.3	
3019	32	

100782

B10-3-31

(14)

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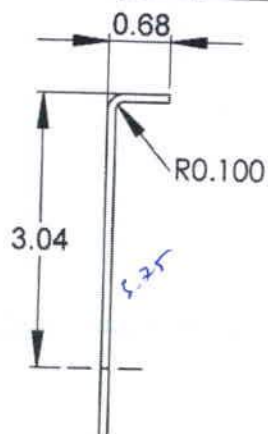
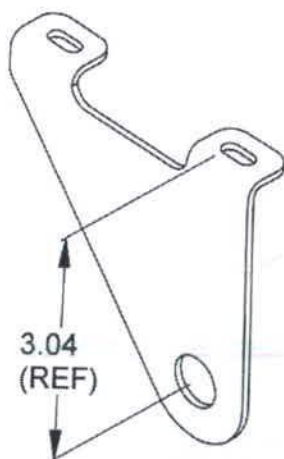
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**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3072	REV. A
DATE 01.12.16		TITLE BRACKET	SHEET 1 OF 1
A	01.12.16	NEW ISSUE	SCALE 1:1
AI 02.01.18 ADD FLAT PATTERN PART NUMBER <i># CP</i>			

**D3072-1/-2 BRACKET**

- 1) MATERIAL: 5052-H32/H34 (AMS 4016/4017/ QQ-A-250/8) 0.090 THICK
- 2) FINISH: POWDER COATBLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

BENDING DETAIL
SCALE 1:2
D3072-1 LH BRACKET SHOWN
(D3072-2 BEND OPPOSITE)

RELEASED
02.01.15 *#*

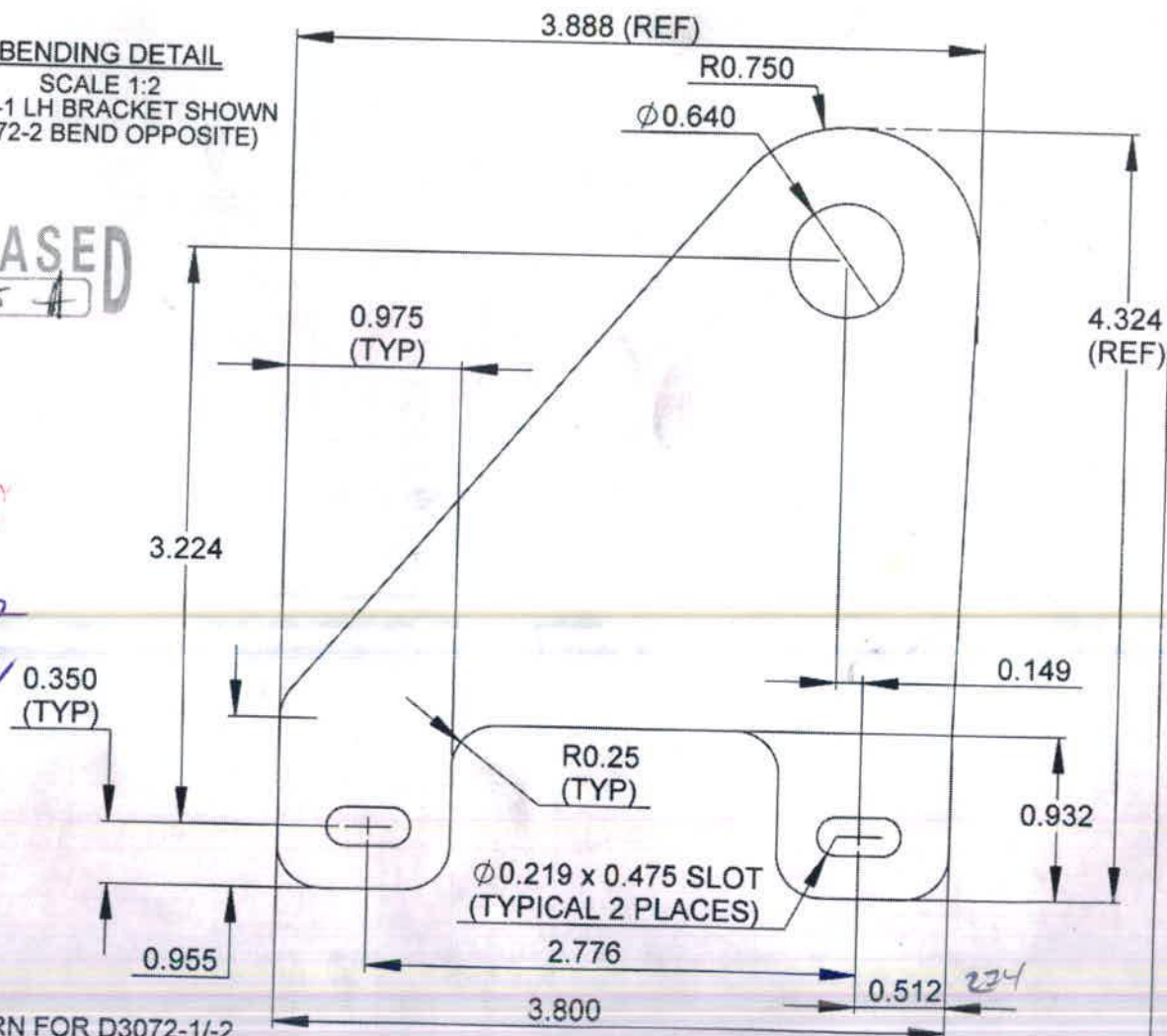
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *57252*

10-3-3



D3072-101

FLAT PATTERN FOR D3072-1/-2



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